












Date: Friday, 24/10/2008 10:33:55 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: A119 STEP WELDMENT LH
Job Number	: 42916A	Part Number	: D3043041
Estimate Number	: 10122	Drawing Number	: D3043 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 24/10/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : LARGE FAB ASSY	Due Date	: 20/11/2008
Previous Run	: 40482A	Qty:	4 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 08-10-24</u>		
Comment	: Est Rev : A New Issue JLM 05-11-01		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: D2622-120 extrusion Batch: <u>B39316</u> <u>SAD</u> <u>08/11/05</u> (4)			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
			
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G 2-Deburr and bevel ends for welding <u>SAD</u> <u>08/11/05</u> (4)			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>Sosullos (x4)</u>			
4.0	D2734	Step End Plate	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2734 End Cap <u>B39179</u> <u>88</u> <u>08.11.11</u> (8X)			
5.0	D30401	Mounting Lug	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3040-1 Mounting Lug <u>B33896</u> = 6 <u>B 42944</u> = 2 <u>SP</u> <u>08.11.11</u> (8X)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 10:33:55 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT LH

Job Number: 42916A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug

B 40492

SP 08.11.11

8X

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8802

AR AL ROD Batch: H 109213

H 104855

2-Grind Fwd End Cap weld flush

→ SAD 08.11.12 SP 08.11.12

4X

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/13 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.13 (4)

LH's

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

4X

1-Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/14

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch: H 104855

2-Inspect for foreign object as per QSI 024

SP 08.11.17

4X

3-Grind Fwd End Cap weld flush

SAD 08-11-17

4X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: A119 STEP WELDMENT LH

Job Number: 42916A

Part Number: D3043041

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08/11/17 (4)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soot 11/17 (4 LH)

14.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

4x LH

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/17

15.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

08-11-17

(4 LH)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320 OF
9:30

M-L 08/11/18

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M 109817

(4)

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

FL 08/11/18

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P 8/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 42916A

Part Number: D3043041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP42916

08/11/09 (14)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05. *[Signature]*

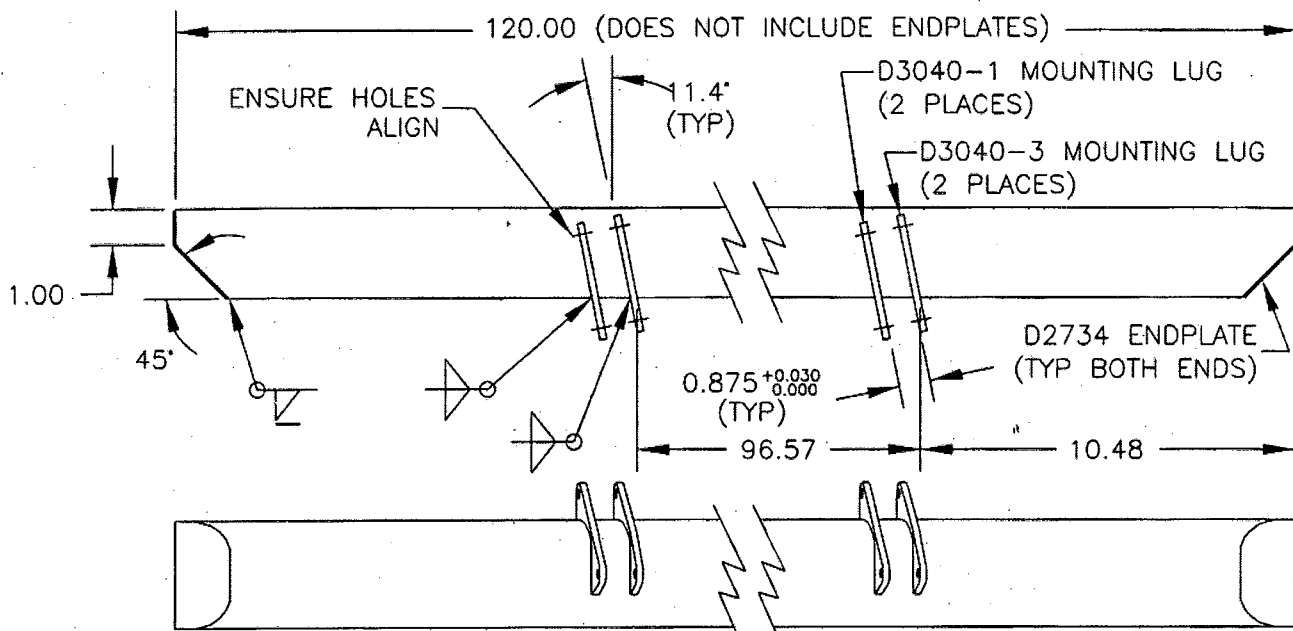
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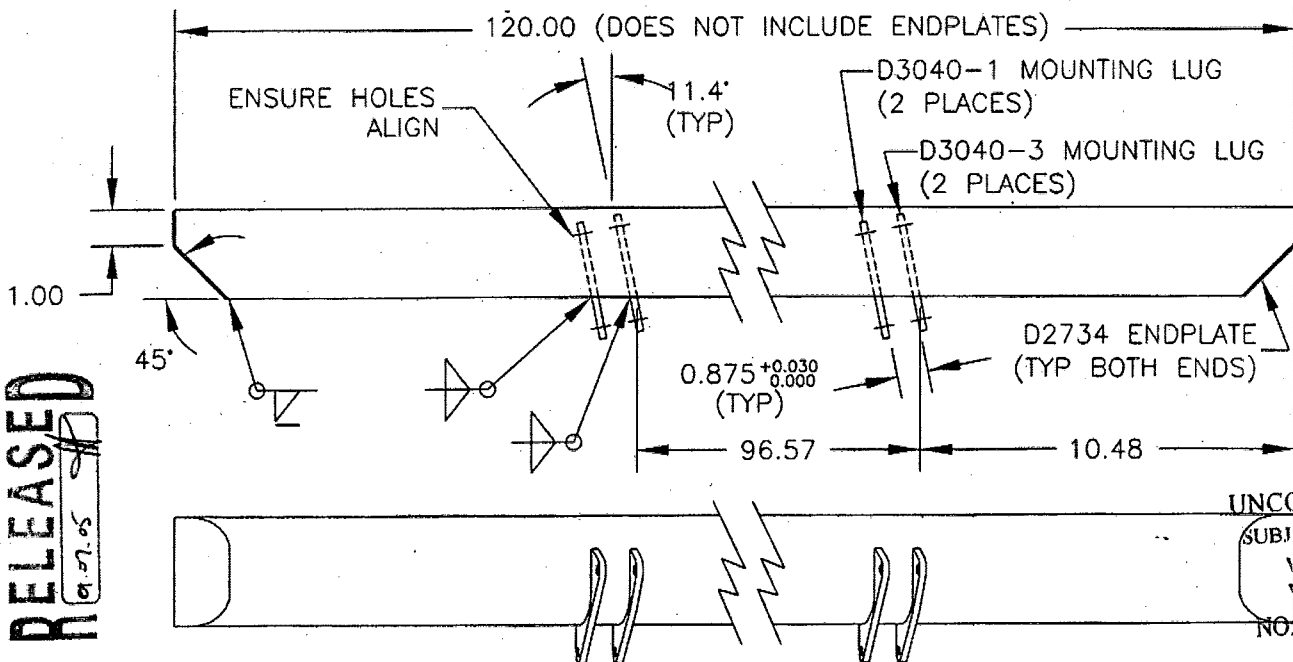
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CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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